

SOLD



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3492-1

Job Sheet 172909



Part No: D3492-1

Job Qty: 100 ea

Part Name: Plug



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/22/18

Job Tracking No:

Due Date: 3/5/18

Created By: Logan David

Type: **SOLD**

Description:

Note: DWG REV E IPP Rev:A 11.04.19 per dwg revC DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	100 Ea	3/3/18	3/3/18	0.00	0.00	Start Up Machining-2		JB 18-03-20
100	Hardinge	100 pcs	3/3/18	3/3/18	0.00	3.06	Hardinge		JB 18-03-20
120	QC	100 pcs	3/3/18	3/3/18	0.00	0.00	QC8		JB 18-03-20
150	HandFinish	100 pcs	3/3/18	3/3/18	0.00	0.33	HandFinish1		SA 18-3-22
155	Outsource H/A	100 pcs	3/3/18	3/3/18	0.00	0.00	Outsource11		BR 18-3-22
160	Powdercoat	100 pcs	3/5/18	3/5/18	0.00	0.16	Powdercoat1		DAS
165	Packaging	100 pcs	3/5/18	3/5/18	0.00	0.00			11 MAR 2
170	QC	100 pcs	3/5/18	3/5/18	0.00	0.00	QC3		9-89/18-3-22
180	Packaging	100 pcs	3/5/18	3/5/18	0.00	0.00	Packaging3-1		21 MAR 2 3 2018
190	QC21-SA	100 Ea	3/5/18	3/5/18	0.00	0.00	QC21		

Part Op 100 - 1-Turn as per Folio FA633 & Dwg D3492 Dwg Rev:

Descriptions: 160 - (Flat End Only) START TIME: 1:45 FINISH TIME: 2:15 O.V.T. 300° M 138 760.

180 - LOCATION : FP001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.625	6061-T6 Round Bar .625"	5.3000 ft (.053 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R0.625	5	24	0



Container No: S052900



Part: D3492-1

Job No: 172909

Serial No/Batch: S052900

Revision:

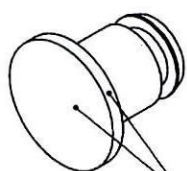
Inspector:

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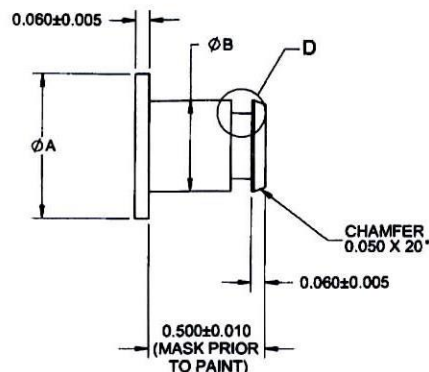
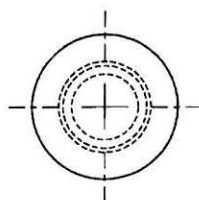
Date: 03/20/18

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Plug	0.060inches $\pm$ 0.005	0.065 0.055		
2	Plug	0.060inches $\pm$ 0.005	0.065 0.055		
3	Plug	0.394inches $\pm$ 0.010	0.404 0.384		
4	Plug	0.625inches $\pm$ 0.010	0.635 0.615		
5	Plug	0.090inches + 0.000 - 0.002	0.090 0.088		
6	Plug	0.500inches $\pm$ 0.010	0.510 0.490		
7	Plug	0.050inches + 0.000 - 0.002	0.050 0.048		
8	Plug	0.050inches $\pm$ 0.010	0.060 0.040		
9	Plug	20.000Degrees $\pm$ 0.000	20.000 20.000		

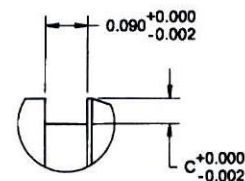
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POWDER COAT THESE
FACES ONLY PER NOTE 2



D3492-XX PLUG



DETAIL D

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.050	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.510	0.045	M6061T6R0.750
D3492-15	0.850	0.640	0.050	M6061T6R0.875

NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

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WORK ORDER
NO. 172951

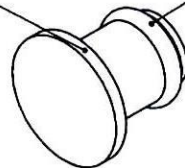
20180222

RELEASED
- 2013-11-13

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ALS	DRAWING NO.	REV. E
MFG. APPR.	DS	D3492	SHEET 2 OF 2
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	PLUG	4:1
DATE	13.08.08	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

D3492-XX PLUG
(SEE TABLE)

NAS1611 O-RING
(SEE TABLE)



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D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	QTY -055	PART NUMBER	DESCRIPTION
X								D3492-041	PLUG ASSEMBLY
	X							D3492-043	PLUG ASSEMBLY
		X						D3492-045	PLUG ASSEMBLY
			X					D3492-047	PLUG ASSEMBLY
				X				D3492-049	PLUG ASSEMBLY
					X			D3492-051	PLUG ASSEMBLY
						X		D3492-053	PLUG ASSEMBLY
							X	D3492-055	PLUG ASSEMBLY
1								D3492-1	PLUG
	1							D3492-3	PLUG
		1						D3492-5	PLUG
			1					D3492-7	PLUG
				1				D3492-9	PLUG
					1			D3492-11	PLUG
						1		D3492-13	PLUG
							1	D3492-15	PLUG
		1						NAS1611-005	O-RING
			1					NAS1611-007	O-RING
1						1		NAS1611-010	O-RING
							1	NAS1611-012	O-RING
	1							NAS1611-013	O-RING
					1		1	NAS1611-015	O-RING
				1				NAS1611-016	O-RING

NOTES:
1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

RELEASED
2013-11-13

E	ADD -055 PLUG ASSY & -15 PLUG	AP	13.08.08
D	INCORPORATED DEO D3492-C-1. SHT 2 DIM C FOR -1 WAS 0.055. (SEE PART11-045)	AJS	11.05.24
C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	ALS	DRAWING NO.	REV. E
MFG. APPR.		D3492	SHEET 1 OF 2
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